



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 164051-A



Part No: D350-591-312

Job Qty: 1 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 12/22/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
220	Powdercoat	1 pcs		12/21/17	0.00	0.30	Powdercoat1		BE 18-02-5
230	HandFinish	1 pcs		12/22/17	0.00	0.19	HandFinish3		BED 18-02-05
240	QC	1 pcs		12/22/17	0.00	0.00	QC3		EB
250	Packaging	1 pcs		12/22/17	0.00	0.00	Packaging1-3		
260	QC	1 pcs		12/22/17	0.00	0.00	QC4		SmB
270	Packaging	1 pcs		12/22/17	0.00	0.00	Packaging3-1		SmB
280	QC21-FG	1 Ea		12/22/17	0.00	0.00	QC21		DMS FEB 04 2018

Part Op 220 - START TIME: 1:00 OVEN TEMPERATURE: 320° FINISH TIME: 1:30
Descriptions: 270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

M 138467

wing walk M138711

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
250-Packaging	AN3-35A	2	258	0	0
	AN4-13A	8	1,162	0	0
	AN5-36A	2	184	0	0
	D2230-3	4	159	0	0
	D2618	2	138	0	0
	D2856-400-720	1	155	0	0
	D3235-1	2	55	0	0
	D3278-041	1	16	0	0
	MS21042L3	2	3,000	0	0
	MS21042L4	8	3,183	0	0
	MS21042L5	2	704	0	0
	NAS1149D0363J	4	4,256	0	0
	NAS1149D0463J	16	5,256	0	0
	NAS1149D0563J	4	1,191	0	0

Part Specifications

Specifications could not be found.

000575

Plex 1/16/18 2:50 PM dart.lacelle.linda

1x1616305

DART
AEROSPACE
S032791

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CANADA
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Heli - Access - Step RH - High Gear, Long Step, Aerazur
Float Compatible

PART NO: D350 - 591 - 312
Original Serial #: S027220

Revision:

Operation:
Change No:

Powdercoat Mfg Date: 01/16/18
CHG002 Job No: 164051 - A
CHG001 ps

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

AEROSPACE

TION		AGAINST DEPARTMENT/PROCESS							
Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Approved	☐	Large Fab	☐	Composite	☐	Supplier	☐		
QTY Effective :					MRB (QSI042) Approval				
Disposition					Completed By				
					Lead hand / Supervisor Approval Verification				
					QC / QA Coordinator Approval				
FAULT CATEGORY									
☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong				
☐	Set-up	☐	Folio/Program	☐	Outside Dimensions				
☐	BOM/Route	☐	Grain	☐	Over/Under tolerance				
☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect				
☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing				
☐	Contamination	☐	Out of Sequence	☐	Part Moved				
☐	Countersink	☐	Off-set	☐	Drawing				
☐	Cut Too Short	☐	Mislabeled	☐	Finish				
☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread				
☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence				

Tribal Knowledge ☐
LOA ☐
Substation ☐
Past Expiry Date ☐
Misidentified ☐

Rushing ☐
Product Improvement ☐
Process Improvement ☐
Manufacturing Process ☐
Past Due ☐

Heat Treat ☐
Wave/Twist in Tube ☐
Marks/Chatter ☐

OTHER :



Dart Aerospace Ltd.
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Master Unit 000575

Tel (613) 632-5200

Containers on Master Unit 000575				
Serial No	Part No	Customer Part No	Status	Quantity
S039799	AN3-35A		Allocated	2
S039798	AN4-13A	AN4-13A	Allocated	8
S039797	AN5-36A	AN5-36A	Allocated	2
S039803	D2618	D2618	Allocated	2
S039802	D2856-400-720	D2856-400-720	Allocated	2
S039801	D3235-1	D3235-1	Allocated	2
S039800	D3278-041	D3278-041	Allocated	1
S039796	MS21042L3	MS21042L3	Allocated	2
S039795	MS21042L4	MS21042L4	Allocated	8
S039794	MS21042L5	MS21042L5	Allocated	2
S039793	NAS1149D0363J	NAS1149D0363J	Allocated	4
S039792	NAS1149D0463J	NAS1149D0463J	Allocated	16
S039791	NAS1149D0563J	NAS1149D0563J	Allocated	4

D22303 S040584
DSI 9410-011 S019728



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Serial No	Part No	Customer Part No	Status	Quantity
S039799	AN3-35A		Allocated	2
S039798	AN4-13A	AN4-13A	Allocated	8
S039797	AN5-36A	AN5-36A	Allocated	2
S040504	D2230-3	D2230-3	Allocated	4
S039803	D2618	D2618	Allocated	2
S039802	D2856-400-720	D2856-400-720	Allocated	2
S039801	D3235-1	D3235-1	Allocated	2
S039800	D3278-041	D3278-041	Allocated	1
S039796	MS21042L3	MS21042L3	Allocated	2
S039795	MS21042L4	MS21042L4	Allocated	8
S039794	MS21042L5	MS21042L5	Allocated	2
S039793	NAS1149D0363J	NAS1149D0363J	Allocated	4
S039792	NAS1149D0463J	NAS1149D0463J	Allocated	16
S039791	NAS1149D0563J	NAS1149D0563J	Allocated	4

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
8	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.